Work Order I June-24-13 1:59:31			*10?	3622) *						Page 1	
Item ID: D22 Revision ID: Item Name: Step			Accept	*N!	900	040	100)* s	etup Star Sto	I	S1*	
Start Date: 6/24. Required Date: 6/28. Reference:	/13 Start Qty: 20.9	, , ,			st Item II stomer:	D:						
,	cess Plan: MLJ		Tooling: SPC (Y/N):			ıte:		R	tun Star Sto	" \	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Τ	ool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.	_
Draw Nbr	Revision Nbr											
D2278	Rev F											
*100 *100* Waterjet	FLOW WATER JET	Γ	0.00					20	0		Jm13-07	02
FLOW CNC Waterjet	1-Cut a	s per Dwg D2278 Dwg Rev:_ if necessary	F_Prog Rev:_F	2-								
110	QC2- Inspect parts of	off machine FAI/FAIB	0.00									**************************************
110 QC Quality Control	Мето		0.00					70	0		Jm13-07	1-02
120	QC8- Inspect parts -	- second check	0.00							D	A	
120 QC Quality Control	Memo		0.00					, (3)	B-07-	೨೬ 0	3 6	er Verste

DQA:			Date:			WORK ORDER NON	~	281501		IDD ATE					ART
QA Closed:			Date:			WORK ORDER NON	-C(JNFOI	RIMANCE / U		Wc	ork Order up	date only	A E F	ROSPACE
Work Orde	· r·					DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS		
WOIK OIGE	-					Rework	1		Skid-tube	Crosstube			Water Jet	Enginee	ring
Part N	10					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		ality
rarer	-					Use-as-is			noforming	Finishing	\dashv		e/Packaging		ther
NCR N	lo					Suspected Unapproved			Large Fab	Composite		1100,000	Supplier		
Root					Desc	ription of work order update		Initial	Ac	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Ins	spector
Design	_														·
Doc/Data	_														
Equip/Tooling	_	•													
Handling/Pre	_						}		-						
Material	_														
Operator															
Offset/Setup	_														
Process	_														
Supplier															
Training	_														
Transport	<u>. </u>														
Unapproved					<u> </u>		<u> </u>								
							FAI	ULT CAT	TEGORY						
Landir						General		1				Ī		-	
		Bending			<u> </u>	Bend		4	Program		-	Outside Dim	 	Pressure/F	orced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	L	Grain				Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	it _	Temperatu	ure/Cure
	\dashv	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u></u>	4	ion Incomplete/U	-		Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruct	tions Incomplete/	/Unclear		Part Moved		Wrong Sto	ck Pulled
		Crushing				Countersink		Misalig	gned/off center			Positioned V	/rong	_	
	_	Heat Trea				Cut Too Short	<u></u>	Mislabe	eled			Power Loss/	Surge	Other	
	-	Inspection		Tube,		Drawing	<u></u>	Misread	b						
		Marks/Ch	atter	,	·.	Drill Holes		Off-set							
		Turning S	equence			Finish		Out of (Calibration						
	Ī	Wave/Tw	ist in Tub)e		Fit/Function		Out of	Seguence						

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Work Order ID 103622 *103622* Page 2 June-24-13 1:59:31 PM Accept Item ID: D2278 *N900040100* Setup Start **Revision ID:** Item Name: Step Leg **Start Qty: 20.00** 6/24/13 **Start Date: Cust Item ID:** Req'd Qty: 20.00 Required Date: 6/28/13 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: **SPC (Y/N):** Date: Sequence ID/ Set Up/ Tool ID Reject Reject Operation Tool # Plan Accept Insp. Work Center ID Qty Qty Stamp Code Number Description **Run Hours** Chemical Conversion Coat per QSI005 4.1 130 0.00 *130* HandFinish 0.00 Memo Hand Finishing QC3-Inspect Part Finish 0.00 140 *140* 0.00 Memo Quality Control Identify as per dwg & Stock Location - A

0.00

0.00

Memo

150

150

Packaging

Packaging

DQA:			Date:										DA DT
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFO	RMANCE / UP		ork Order up	udate only	AEROS PACE
QA Closed.	_		- Date.			DISPOSITION					·		
Work Orde	er:				,	DISPOSITION				AGAINST D	PARTMENT	PROCESS	
	_					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	moforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo	· · · · · · · · · · · · · · · · · · ·				Suspected Unapproved			Large Fab	Composite]	Supplier	
Root					Desc	ription of work order update		nitial	Actio	on	Sign &	<u> </u>	1
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design										-			
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved							<u> </u>						
·							FA	ULT CA	TEGORY				
Landi	ng G	ear				General					_		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Ц	Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Ц'	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure
	(Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
	Ц'	Cuffs			L	Contamination		Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
	Щʻ	Crushing				Countersink		Misalig	gned/off center		Positioned V	vrong	_
	-	Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	_	Inspection	· .	Tube	<u> </u>	Drawing		Misread	d		<u></u>		· · · · · · · · · · · · · · · · · · ·
!		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence		, ·	Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Order <i>June-24-13 1:59:3</i>		03622		*103	3622*							Page 3
Revision ID:	2278 ep Leg		:	Accept	*N900	040	100)*	Setup	Start Stop	*N	S1* S2*
	24/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					IV	
Approvals: P	Process 1	Plan:	Date:	Tooling:	Da	ıte:	-]	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ıte:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
160 QC Quality Control		Мето		0.00						13/	114	WC 13-94

tion Policy (Spring) Policy (Spring) Policy (Spring)

DQA:			Date:										**	$^{\mathcal{L}}$ aaa $\mathbb{C}^{\mathcal{L}}$
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS		
	-					Rework	1		Skid-tube Crosstu	be 🗀		Water Jet		Engineering
Part N	١o.					Scrap			Machining Small F		Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Therr	noforming Finishi	ng	-4	re/Packaging		Other
NCR I	۱o. <u>-</u>					Suspected Unapproved]		Large Fab Composi	te]	Supplier		
Root					Desc	ription of work order update		Initial	Action		Sign &		T	
Cause	ŀ	Date	Step	Qty		or non-conformance		nief Eng	1		Date	Verification		QC Inspector
Design													\top	
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator													1	
Offset/Setup														
Process														
Supplier													ļ	
Training														
Transport												i	1	
Unapproved														
							FA	ULT CA	TEGORY					
Landi	ng G	ìear			_	General		_			_			
	Ш	Bending			<u> </u>	Bend		Folio/F	Program		Outside Dim	ensions	╛	Pressure/Forced
	Ш	Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance		Set-up
	Ш	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa	are	L	Part Incorred	ct [Temperature/Cure
	Ш	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing [Weld
	Ш	Cuffs			L	Contamination		Instruct	tions Incomplete/Unclear	L	Part Moved			Wrong Stock Pulled
	Ш	Crushing			L	Countersink		Misalig	gned/off center	L	Positioned V	Vrong		
	Ш	Heat Trea	it		oxdot	Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
	Ш	Inspectio	n Strip in	Tube		Drawing		Misrea	d					
	Ш	Marks/Ch	natter			Drill Holes		Off-set						
	Ш	Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

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Picklist Print

June-24-13 1:59:31 PM

Work Order ID: 103622

Parent Item:

Comments:

D2278

Parent Item Name:

Step Leg

IPP Rev:A IPP Rev:B

New Issue

JLM

Now 6061-T6 06-06-23 New flat pattern 08.01.11 EC

	IPP Rev C New	flat pattern 08.0)1.11 E	C						<u> </u>			
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	287.8100	0.9815	20.663158	}	Ji	nB-07-02

Location	Loc Oty	Loc Code	
MAT	0.2		
124572	0.2		
MAT021	287.61		
m125812	287.61		125812

Page 1

Required Date: 6/28/13

Start Date: 6/24/13

Start Qty: 20.00

Required Qty: 20.00

DQA:			Date:										TQ AC
			5.			WORK ORDER NON-	-CC	ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:					<u> </u>			/ork Order up	date only	
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming	Finishing	_	re/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite	1	Supplier	1
							•				-		
Root					Desci	ription of work order update	I	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Design		·											
Doc/Data												·	
Equip/Tooling	_												
Handling/Pre	_												
Material				٠.									
Operator	_			A .		•							
Offset/Setup													
Process	_												
Supplier													
Training													
Transport													
Unapproved	<u> </u>												
							FA	ULT CA	TEGORY				
Landi	ng (3			_	General		1		_	- -,		٦ .
ĺ		Bending			<u> </u>	Bend	<u> </u>	4	Program	_	Outside Dim	 	Pressure/Forced
•	-	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		_	Over/Under	<u> </u>	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Incorred		Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs	<u> </u>	- 1 '	ion Incomplete/U	· -	Part Lost/Mi	ssing	Weld
		Cuffs			<u> </u>	Contamination	<u> </u>	-1	tions Incomplete/U	Jnclear	Part Moved	L	Wrong Stock Pulled
	$\overline{}$	Crushing			-	Countersink	ldash	-1	gned/off center	}_	Positioned V		7
	_	Heat Trea			-	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	Other
	_	Inspectio		Tube		Drawing	\vdash	Misrea					
	<u> </u>	Marks/Cl			_	Drill Holes	<u> </u>	Off-set					
	_	Turning S			· •	Finish	<u></u>	4	Calibration				
	1	Wave/Tw	vist in Tub	e	- l · .	Fit/Function	1	Out of	Sequence				

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DART AEROSPACE LTD	Work Order:	103622
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	0.352	_		ν	Jkmoi
0.354	+/-0.010	0.354"	-		V	
16.46	+/-0.030	16.46"	-		T	Jemo6
Ø0.128	+0.005/-0.000	0.138,	_		V.	
R0.354	+/-0.030	6.354"	-		RG	
2.00	+/-0.030	2.005"	_		V	
4.74	+/-0.030	4. 344"	-		V	
8.46	+/-0.030	8.466"	-		V	Rodutoz
0.213	+/-0.010	0.214"	~		V	. 55 50 6
0.750	+/-0.010	0.754"	<u>_</u>		V	
0.080 thick	+/-0.010	0.077	~		V	
·						

Measured by: JM	Audited by:	Dar	Prototype Approval:	N/A
Date: 1307.02	Date:	13.07.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.10.12	New Issue P/O D2582	KJ/JLM	
В	06.03.08	Dwg Rev. changed	KJ/JLM	
С	06.06.23	Dwg Rev. changed	KJ/JLM	
D	08.02.28	Dimensions updated per Dwg Rev F	KJ/DD	1/2

